

Work Order ID 70075

Thursday, May 26, 2011 11:24:56 AM



Page 1

Item ID: D2480-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access Handle Weldment RH

Start Date: 5/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

11-05-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D2480

Rev A1

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

Weld as per Template DT 8333 (DT 2480 CJ)

11-8-15 (X3)

110

0.00



QC9- Inspect visual per QSI004- Fusion Welds

QC

Memo

0.00

Quality Control

11.08.15 (3)

120

0.00



QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

5/10/08/15

(X3) RM

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70075

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Item ID:	D2480-012	Accept		Setup	Start	
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Item Name:	Heli-Access Handle Weldment RH					
Start Date:	5/26/2011	Start Qty:	2.00		Cust Item ID:	
Required Date:	6/3/2011	Req'd Qty:	2.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel Memo START TIME: 10:00 FINISH TIME: 4:00 OVEN TEMPERATURE: 10:30	0.00 0.00							3 X Ø M-L 11/08/19 RH.
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							3 BR 11.8.22
150 Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00							11/8/24 SD 30

W/O:		WORK ORDER CHANGES					
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Item ID: D2480-012

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access Handle Weldment RH

Start Date: 5/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/25

CL 11/08/25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Thursday, May 26, 2011 11:25:04 AM

Work Order ID: 70075

Parent Item: D2480-012

Parent Item Name: Heli-Access Handle Weldment RH





Start Date: 5/26/2011

Required Date: 6/3/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP C1 03.01.09 Added Powder Coat

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2478  Heli-Access Handle		Manufactured	No			100	Each	7.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				7					
				66814				7					
D2479  Heli-Access Handle		Manufactured	No			100	Each	7.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				7					
				66815				7					
D2481  Mounting Plate		Manufactured	No			100	Each	19.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA020				19					
				65823				19					
D2482  Mounting Plate		Manufactured	No			100	Each	49.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA020				49					
				38319				40					
				40635				9					

EL 11-8-15

3

EL 11-8-15

3

EL 11-8-15

6

EL 11-8-15

3

W/O:		WORK ORDER CHANGES					
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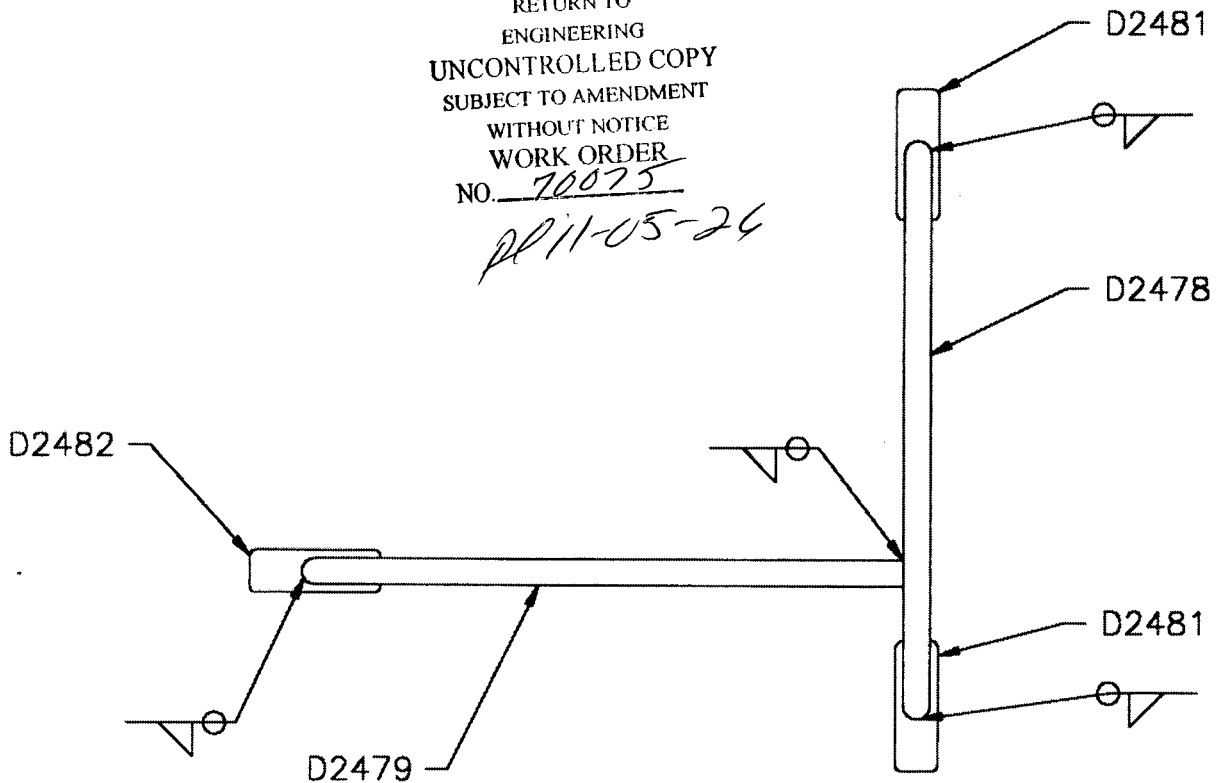


DESIGN B WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>BW</i>	APPROVED <i>BW</i>	DRAWING NO. D2480	REV. A SHEET 1 OF 1
DATE 96:05:14		TITLE HANDLE WELDMENT ASSEMBLY	SCALE 8:1
A1 <i>11/05.06.23</i>		ADDED POWDER COAT	

RELEASED
96/10/02 DS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70075

PR11-05-24



D2480-011 LH SHOWN
D2480-012 RH OPPOSITE

NOTES:

- 1) WELD PER TEMPLATE DT 2480 WG PER QSI 004
2) POWDER COAT WHITE GLOSS (REF: 4.3.5.2) AS PER QSI 005

W/O:		WORK ORDER CHANGES					
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